Date:

Monday, 05/03/2007 11:55:02 AM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Drawing Name

: LUG

Job Number

: 30994

Due Date

Estimate Number P.O. Number

: 11019

:NIA

Part Number

: D27313

This Issue

: 05/03/2007

S.O. No. : 1/12

Drawing Number

. D2731 REV B

: 03/12/2007

Prsht Rev. First Issue : NC : 01/03/2007

: MACHINED PARTS

Project Number

: N/A

Previous Run

: 29781

: B **Drawing Revision** Material

AIG:

Qty:

50 Um: Each

Written By

Checked & Approved By

Comment

Type

Added inspect level 8, removed P/O for powder

coating EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2423

Lug Extrusion



Comment: Qty.:

3.5858 f(s) 0.0717 f(s)/Unit Total:

Lug Extrusion D2423 Batch: 30062

2.0

BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion: 0.82" Long

3.0 PG **PURCHASING**



Comment: PURCHASING Issue P/O BLKT 00001

Possible Supplier: Metec

CL07/03/08(5)

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for transit damage

Machine per Drwg D2731 Rev.B

5.0

QC5

Comment: INSPECT WORK TO CURRENT STEP

INSPECTATORK TO CURRENT

Monday, 05/03/2007 11:55:02 AM Date: User: Linda Lacelle **Process Sheet Drawing Name: LUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 30994 Part Number: D27313 Job Number: Description: Seq. #: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 POWDER COATING POWDER COATING 7.0 m 104144 **Comment: POWDER COATING** Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE PACKAGING 1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: SF QC21 10.0 81106/18 Comment: FINAL INSPECTION/W/O RELEASE h 87.0018 Job Completion

Dart Aerospace Ltd. Thursday, 3/1/2007 11:34:03 AM Date: Kim Johnston User: **Process Sheet** : LUG **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 30994 : 11019 **Estimate Number** : D27313 **Part Number** P.O. Number . D2731 REV B **Drawing Number** : 3/1/2007 S.O. No. : This Issue : N/A Project Number Prsht Rev. : NC ; B : MACHINED PARTS : // **Drawing Revision** Type First Issue : 29781 Material Previous Run : 12/3/2007 Qty: 50 Um: **Due Date** Written By Checked & Approved By Added inspect level 8, removed P/O for 09.05.19 : Est:D Comment powder coating EC **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: Lug Extrusion 1.0 Comment: Qty.: 0.0717 f(s)/Unit Total: 3.5858 f(s) Lug Extrusion D2423 Batch: BAND SAW BAND SAW 2.0 Comment: BAND SAW Cut D2423 Extrusion: 0.82" Long AAS CNC VERTICAL MACHINING #1 3.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2731-3 Check for crack while loading into the machine Tumble Deburr any rough edges after tumbling INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 5.0 QC8 Comment: SECOND CHECK

Each

Dart Aerospace	e Ltd
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Dart Ae	rospace	Lta								
W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP			ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQA	\:	Date:	
						QA: N	/C Closed	:	_ Date:	
NCR:		1	NORK ORE	ER NON-CONF	RMANCE	(NCR	3)			
D.4.T.E.	0750	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descri	otion	Sign & Date	Section		Chief Eng	QC Inspector
								·		

NOTE: Date & initial all entries

Date:

Thursday, 3/1/2007 11:34:03 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 30994

Part Number: D27313

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Da	rt	Ae	ros	pace	Ltd
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W/O:		WORK ORDER CH	ANGES
DATE	STEP	PROCEDURE CHANGE	By Date Qty Approval Chief Eng / Prod Mgr QC Inspector
L			
Part No	:	PAR #: Fault Category:	NCR: Yes No DQA: Date:

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action	Section B		Varification		Ammanal
DATE	STEP	Section A Initial Action		Action Descri			Verification Section C	Approval Chief Eng	Approval QC Inspector
						-			
		: .		:					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30994
Description: Lug	Part Number:	D2731-3
Inspection Dwg: D2731 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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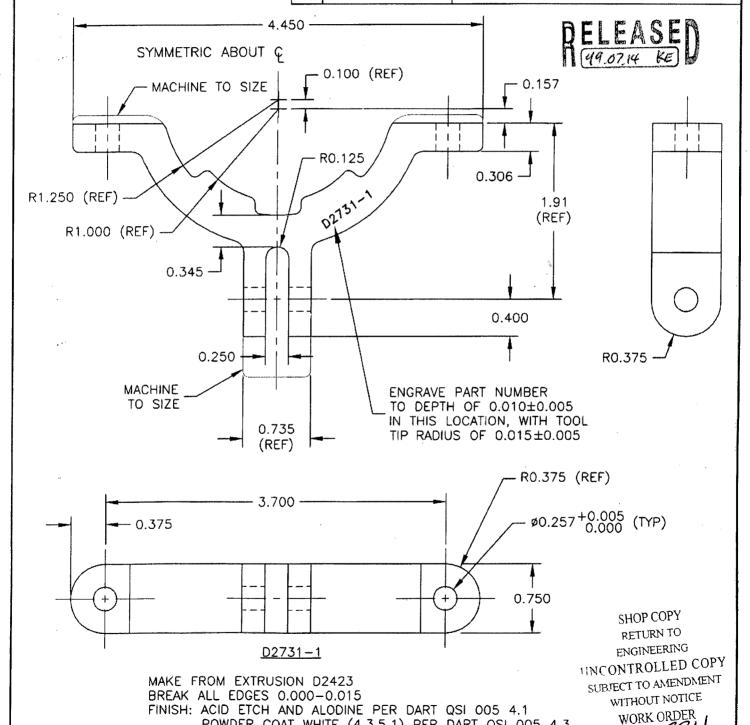
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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1.41	+/-0.030					
0.306	+/-0.010					
0.413	+/-0.010					
3.700	+/-0.005					
0.375	+/-0.010					
0.750	+/-0.010					
Ø0.257	+0.005/-0.000					
0.100 X 45°	+/-0.010					
						·

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.22	New Issue	KJ/RF	14



DESIG	KE	DRAWN BY	DART AEROSPACE	
CHEC	KED	APPROVED	DRAWING NO.	REV. B
	KE	1 (1)	D2731	SHEET 1 OF 4
DATE		'''''''	TITLE	SCALE
99.0	7.06		MOUNTING LUG	1:1
Α		98.05.13	NEW ISSUE	
В		99.07.06	REVISED DIMENSIONS	

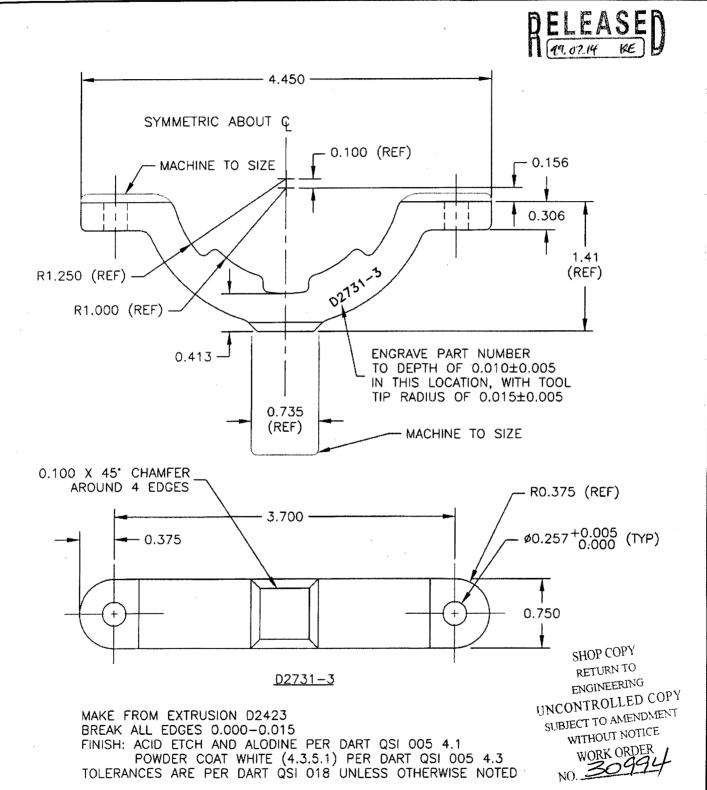


POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED NO. 3099

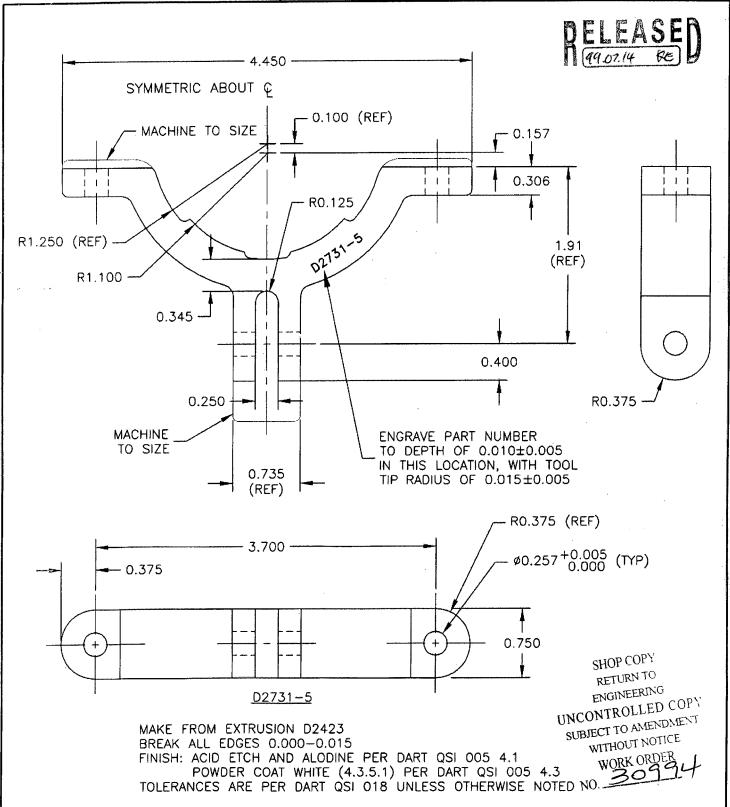


	DESIGN,	DRAWN BY	DART AEROSPACE FAIRCHILD INTERNATION	
	CHECKED HE	APPROVED	DRAWING NO. D2731	REV. B SHEET 2 OF 4
	DATE		TITLE	SCALE
ļ	99.07.06		MOUNTING LUG	1:1





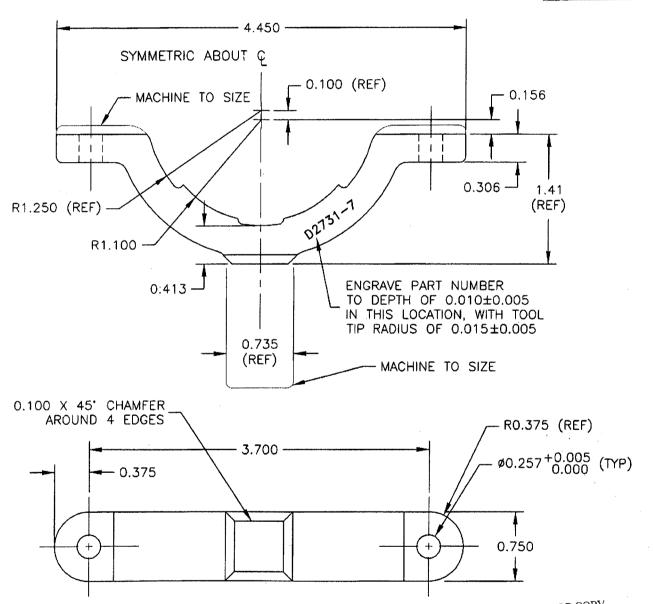
DESIGN LE	DRAWN BY	DART AEROSPA	
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 3 OF 4
DATE	<u> </u>	TITLE	SCALE
99.07.06		MOUNTING LUG	1:1





DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 4 OF 4
DATE	17	TITLE	SCALE
99.07.06		MOUNTING LUG	1:1

RELEASED



MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2731-7

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER 4



CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street

Hawkesbury, Ont.

K6A 1K7

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
30	D2230-3	Lug B30993	BLKT00001
50	D2731-3	Lug B30994	BLKT00001
50	D2731-7	Lug B30995	BLKT00001
150	D3235-1	Lug B30996	BLKT00001
50	D3394-1	Lug B30997	BLKT00001
50	D3394-3	Lug B30998	BLKT00001

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hilf, June 12, 2007